

Work Order ID 159849

Wednesday, April 19, 2017 11:36:05 AM

159849

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Item ID: D4062-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Tank Support Assembly
Start Date: 4/21/2017 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 5/3/2017 Req'd Qty: 4.00 ***4*** Customer:
Reference: SCHEDULED/S

Approvals: Process Plan: DAS 21 Date: APR 20 2017 Tooling: _____ Date: _____ Run Start ***NR1***
QC: 9-39 Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4062	E								
100		0.00							
100									
Waterjet	Memo	1.00							
FLOW CNC Waterjet	CUT BLANK AS PER FILE D4062-1_BLANK								
102	QC2- Inspect parts off machine FAI/FAIB	0.00							
102									
QC	Memo	0.04							
Quality Control									
105		2.68							
105									
HAAS 1	Memo	1.38							
HAAS CNC vertical machine #1	MILL AS PER DWG AND FOLIO FA949 DWG REV: <u>E</u> FOLIO REV: <u>AA</u>								

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Item ID: D4062-041**Accept*****N900040100*****Setup Start*****NS1*****Revision ID:****Stop*****NS2*****Item Name:** Tank Support Assembly**Start Date:** 4/21/2017 **Start Qty:** 4.00***4*****Cust Item ID:****Required Date:** 5/3/2017 **Req'd Qty:** 4.00***4*****Customer:****Reference:** SCHEDULED/S**Approvals:****Process Plan:** _____**Date:** _____**Tooling:** _____**Date:** _____**Run Start*****NR1*****QC:** _____**Date:** _____**SPC (Y/N):** _____**Date:** _____**Stop*****NR2*****Sequence ID/
Work Center ID****Operation
Description****Set Up/
Run Hours****Tool ID****Tool #****Plan
Code****Accept
Qty****Reject
Qty****Reject
Number****Insp.
Stamp**

106

QC2- Inspect parts off machine FAI/FAIB

0.00

106

QC

Memo

0.04

Quality Control

5

17-05-29

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.08

Quality Control

5

10

DAS
14
9-89

17/05/29

140

Identify as per dwg & Stock Location: _____

0.00

140

Packaging

Memo

0.04

Packaging

LOCATION: WA003

5

DAS
9-89

MAY 31 2017

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Item ID: D4062-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Tank Support Assembly
Start Date: 4/21/2017 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 5/3/2017 Req'd Qty: 4.00 ***4*** Customer:
Reference: SCHEDULED/S

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.40							
Quality Control									

DAS
21
9-89

MAY 31 2017

Picklist Print

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Parent Item: D4062-041

D4062-041

Parent Item Name: Tank Support Assembly

Start Date: 4/21/2017

Required Date: 5/3/2017

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A NEW ISSUE 11-11-23 JLM VERIFIED BY:DD IPP
REV:B AS PER REV C 12-03-08 JLM VERIFIED BY:DD IPP REV:C
AS PER REV D 13-07-16 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB1.250		Purchased		No		100	sf	49.0000	3.645	15.34737			

MUHMWB1 250

UHMWB 1.250 BLACK

04/17/04/27

Location	Loc Qty	Loc Code
MAT019	49	
m127198	11	
m136844	38	

9
11.6

DART AEROSPACE LTD		Work Order: 159849
Description: Tank Support Assembly		Part Number: D4062-041
Inspection Dwg: D4062	Rev: E	Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
31.38	+/-0.030	31.375			tape	
0.63	+/-0.030	.623			vern LPO9	
3.50	+/-0.030	3.497			↓	
3.66	+/-0.030	3.655			↓	
11.98	+/-0.030	11.980			tape	
1.50	+/-0.030	1.500			vern LPO9	
3.10	+/-0.030	3.099			↓	
4.85	+/-0.030	4.849			↓	
10.17	+/-0.030	10.187			tape	
15.49	+/-0.030	15.500			↓	
20.81	+/-0.030	20.812			↓	
27.65	+/-0.030	27.650			↓	
29.88	+/-0.030	29.875			↓	
0.75	+/-0.030	.750			vern LPO9	
0.38	+/-0.030	.380			↓	
1.75	+/-0.030	1.755			↓	
1.75	+/-0.030	1.753			↓	
Ø0.531	+0.008/-0.001	.530			gauge pin	
0.88	+/-0.030	.873			vern LPO9	
4.07	+/-0.030	4.06			↓	
27.30	+/-0.030	27.312			tape	
10.39	+/-0.030	10.390			↓	
6.15	+/-0.030	6.150			↓	
R1.11	+/-0.030	1.109			vern LPO9	
R0.250	+/-0.010	.250			Rad gauge	
R0.250	+/-0.010	.250			↓	
1.25	+/-0.030	1.262			vern LPO9	
0.13	+/-0.030	.150			↓	
0.50	+/-0.030	.500			↓	
0.50	+/-0.030	.501			↓	
2.50	+/-0.030	2.497			↓	
0.375 x 50°	+/-0.010 x +/-0.5°	385			↓	

Measured by: PJT-05-29	Checked by: DAS 14	QC Inspector:
Date: 17/05/29	Date: 17/05/29	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
A	15.09.23	New Issue	KJ	

